

D205.633-011

Dart Aerospace Ltd.

Date: Wednesday, 1/31/2007 2:33:43 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 30508A		
Estimate Number	: 10176		
P.O. Number	: <i>N/A</i>	Part Number	: D2563
This Issue	: 1/31/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2563 REV C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 30461A	Drawing Revision	: C
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 2/20/2007
Checked & Approved By	: <i>[Signature]</i> 07.02.01	Qty:	10 Um: Each
Comment	: Est Rev. C 02.07.31 Re-format Location RF		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2244116 Step Extrusion



Comment: Qty.: 1 Each(s)/Unit Total: 10 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: *328216**P.E. 07-04-30*

10

2.0 D267334 End Plate



Comment: Qty.: 2 Each(s)/Unit Total: 20 Each(s)

Pick:

Qty	Part No.	Description
2	D2673-34	End Cap

Batch: *325396**P.E. 07-04-30*

10

3.0 D2561 Lug Plate



Comment: Qty.: 2 Each(s)/Unit Total: 20 Each(s)

Pick:

Qty	Part No.	Description
2	D2561	Lug Plate

Batch: *330384**P.E. 07-04-30*

10

4.0 D2564 Mounting Angle



Comment: Qty.: 2 Each(s)/Unit Total: 20 Each(s)

Pick:

Qty	Part No.	Description
2	D2564	Mounting Angle

Batch: *321418**P.E. 07-04-30*

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:33:43 PM
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Process Sheet

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Drawing Name: STEP WELDMENT

Job Number: 30508A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

2-Deburr ends

3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M103317
M102756

4-Grind

J.E. 07.04.30 10
J.E. 07.04.30 10
J.E. 07.05.2 10
FF 07-05-03 10

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

J 070515 10

07/05/15 10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 07/05/15

10X

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

J 070515 10

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remainig End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M102756

3-Grind

J.E. 07.05.17 10
J.E. 07.05.17 10
FF 07-05-17 10

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/17 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:33:43 PM
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Process Sheet

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Drawing Name: STEP WELDMENT

Job Number: 30508A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



JAOS-17 (10)



Comment: INSPECT WORK TO CURRENT STEP

12.0

POWDER COATING

POWDER COATING



M103706



(PTC)

Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

JD
FZ

07-05-22

07/05/22

(10)

(10)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M/107281



(10x)

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

M-h

07/05/23

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LC

7/5/24

(10)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



07/05/24

Comment: FINAL INSPECTION/W/O RELEASE

u 07-05-24

Job Completion



PPP SUB B32382 D205-633-011



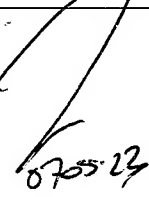



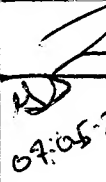
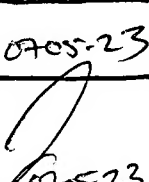


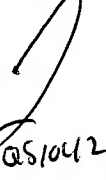
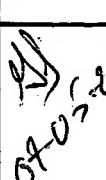
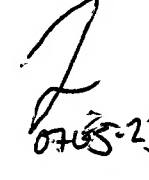
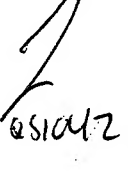
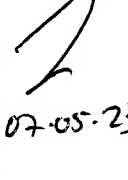
07/05/24 (10)

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

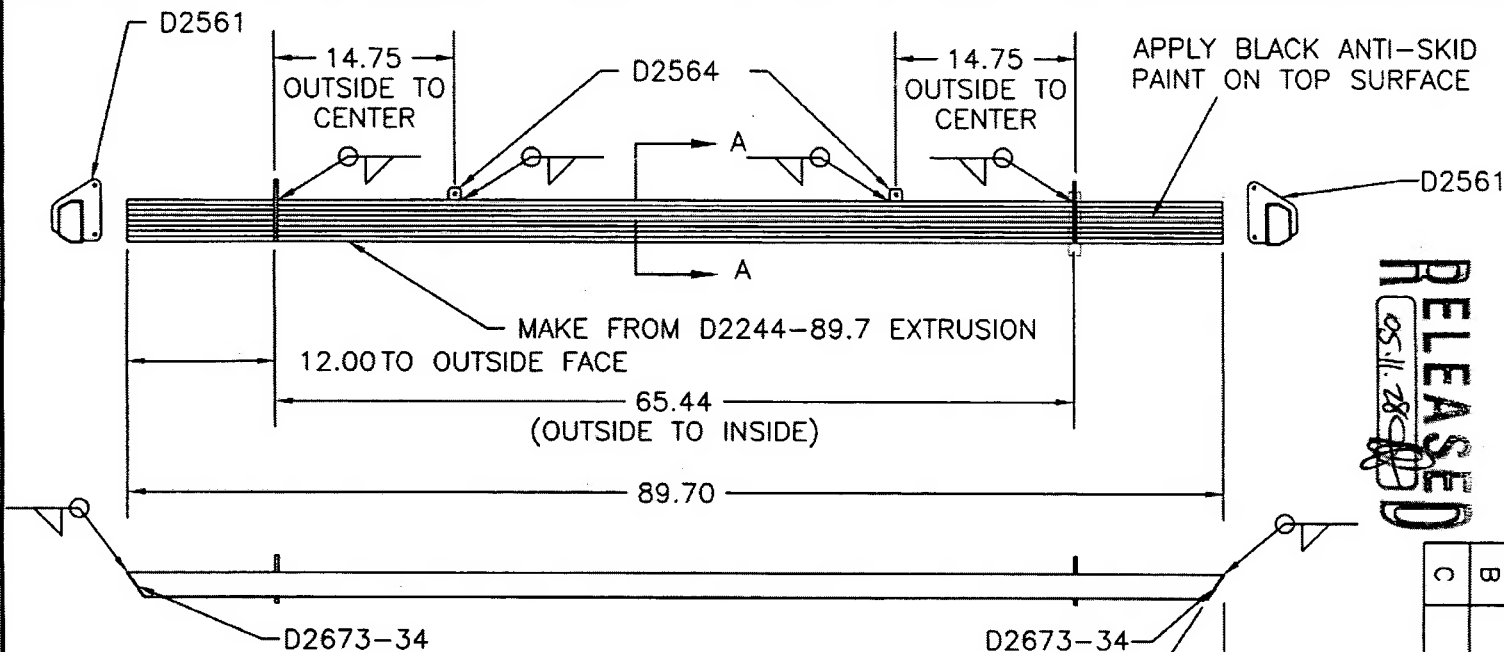
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-23	12.0	4 steps had some yellow strips that came through the powder coating. Root cause: Yellow paint on the buggy rubbed off on the step.	 QS1042	Sand affected area with 320 grit sand paper, and scuff with a red pad on the remainder of the step. Touch-up area's with Alodine	 07-05-23	 07-05-23	 QS1042	 07-05-23
↓	↓	↓	 QS1042	verify by Q.C. Pre-heat steps & re-powder coat white Pressure wash & vince per QS1005	 07-05-23	 07-05-23	 QS1042	 07-05-23
↓	↓		 QS1042	Pre-heat as necessary and re-powder coat per QS1005.	 07-05-23	 07-05-23	 QS1042	 07-05-23

NOTE: Date & initial all entries

DART

05-11-78

DESIGN	BW	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
DATE	05.11.14			D2563	SHEET 1 OF 1
				TITLE	SCALE
				STEP WELDMENT ASSEMBLY	1:15
A				96.04.26	NEW ISSUE
B				97.05.14	END CAPS CHANGED (WAS D2248)
C				05.11.14	UPDATE NOTES



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30508A

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

